Work Order ID 1 Friday, June 21, 2013 4:0			*10.3	367*						Page 1
Item ID: D3914-1 Revision ID:			Accept	*N900	040	100)* s	etup Sta	IA	S1*
Item Name: Rib Start Date: 6/21/2013 Required Date: 7/19/2013 Reference:		* % * * 7 *		Cust Item I Customer:	D:					S9*
Approvals: Process	Plan:	Date/3-66	2// Tooling:	Da	ite:		R		*N	R1*
QC:		Date:	SPC (Y/N):	Da	nte:		- 1.7 - 1.7	Sto	*N	R2*
Sequence ID/ Work Center ID	Operation Description	2	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr F	Revision Nbr									-
D3914 C						100	,			
100		•	0.00.				e de la companya de l		:	1.5 T
100 Large Fab	Memo		0.00				10	SAO	_13	09-24
Large Fab		e as per dwg D3914 and remove identification r	markings		-					
110	QC6- Inspect dimension	ons to drawing	0.00	2 - Mary 1 - 1			17			DAS
110 QC Quality Control	Memo		0.00				10	- ;		13.9.2
					· · · · · · · · · · · · · · · · · · ·					
120	Identify as per dwg &	Stock Location:	0.00		:	•	•			DAG
120 Packaging	Memo		0.00				10		1.00	
Packaging									i	2.9.27

NCR: Y	es / No	1			WORK ORDER NON-	CONFO	RMANCE / UF	PDATE							
	•								QA Closed:	Date	:				
Work Orde	r:	·			DISPOSITION		AGAINST DEPARTMENT/PROCESS								
Part N	0				Rework Scrap	Skid-tube Crosstub Machining Small Fa			4	Water Jet d. Eng. Coor.	Engineering Quality				
NCR N	o	-			Use-as-is Work Order Update	l In	ermoforming Large Fab	Finishing Composite	Rec/Store/Packaging Other Supplier						
Root				Descr	iption of work order update	Initia	A	ction	Sign &						
Cause	Date	Step	Qty		or Non-conformance	Chief E	ng Des	cription	Date	Verification	QC Inspector				
oc/Data															
quip/Tooling															
perator			İ							•					
//aterial			1						}						
etup		1	İ												
Other							İ			1					
rocess															
upplier															
raining			1	ļ						1					
Inapproved															
					F	AULT CA	TEGORY				· · · · · · · · · · · · · · · · · · ·				
Landin	g Gear				General	_			,		_				
	Bendin	g			Bend	Grai	n		Ovalized	L	Pressure/Forced				
	Centre	Not Conce	entric to	o/s _	_BOM/Route	Hard	ware		Over/Under	tolerance	Temperature/Cure				
[Cracks				Broken/Damaged	Insp	ection incomplete		Part Incorre	ct	Weld				
· [Crushe	d/Crimped	ŧ		Burrs	Instr	uctions Incomplete	/Unclear	Part Lost/Mi	issing	Wrong Stock Pulled				
	Cuffs				Contamination	Mai	ntenance		Part Moved						
	Heat Tr	eat			Countersink	Misl	abeled		Positioned V	Vrong					
Ī	Inspect	ion Strip ir	n Tube		Cut Too Short	Misr	ead		Power Loss/	Surge	Other				
Ī	Ripples	in Bend			Drill Holes	Offs	et								
ľ	Torque	Waves in	Extrusio	n 🗆	Drawing	Out	of Calibration								
Ì		g Sequence			Finish	Out	of Sequence		,						
		Twist in Tu			Folio	Outs	ide Dimensions								

Date:

Work Ord Friday, June 21				*103				Page 2			
Item ID: Revision ID: Item Name:	D3914-1			Accept	*N900	040	100*	Setur	Start Stop	ıv.	S1* S2*
Start Date: Required Date: Reference:	6/21/2013	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item I Customer:	D;					
Approvals:	Process Pl	an:	Date:	Tooling:	Da	ate:		Run	Start	*NI	R1*
	QC:	, , , , , , , , , , , , , , , , , , ,	_ Date:	SPC (Y/N):	Da	ate:			Stop	*NI	R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID		Plan Ac Code Qt		-	Reject Number	Insp. Stamp
*130		QC21- Final Inspection	- Work Order Release	0.00			•	det	-/ Rn	n 13/	nalan.
QC		Memo		0.00				// `/-	/ '	, , , , , , , , , , , , , , , , , , , ,	-1101

Quality Control

NCR: Yes	s / No				WORK ORDER NON-O	CONF	ORN	MANCE / UPI	DATE	QA Closed:	Date	:		
Work Order:					DISPOSITION		•			DEPARTMENT/PROCESS				
Part No	·				Rework Scrap Use-as-is		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing			4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other		
NCR No	•		·- ·- ·		Work Order Update] '	Large Fab Composite							
Root				Descri	ption of work order update	Init	ial	Act	tion	Sign &	·			
Cause	Date	Step	Qty	(or Non-conformance	Chief	Eng	Descr	ription	Date	Verification	QC Inspector		
Doc/Data														
quip/Tooling														
Operator	_													
Material	_													
Setup	4				•		1							
Other	4					1								
rocess	_					1								
Supplier	4					1				1				
raining	-													
Inapproved		<u> </u>	<u> </u>			1		CODY		<u> </u>				
						AULT (LAIE	JUKY						
Landing	_			Г	General		rain		Γ_	Ovalized		Pressure/Forced		
<u> </u>	Bending			,, -	Bend	—			<u> </u>	Over/Under	talaransa	Temperature/Cure		
L	Centre No	ot Concer	itric to (U/S -	BOM/Route Broken/Damaged	-	ardwa	re on Incomplete	-	Part Incorred	·	Weld		
-	-	C		-	⊣ ' ' ~ ~	\vdash	•	on incomplete ions incomplete/l	Uncloar	Part Lost/Mi	 	Wrong Stock Pulled		
_	Crushed/	Crimpea		-	Burrs			nance	- Inclear	Part Moved	22111R			
-	Cuffs	. ·		-	Countercial		islabe		-	Positioned V	Vrong			
-	Heat Trea		Tubo	<u> </u>	Countersink	-	isiabe isread		·	Power Loss/		Other		
_	Inspection Strip in Tube Cut Too Short Ripples in Bend Drill Holes						isread ffset	ı	L.	T. OMEL FOSS	Juige L	Journe		
-	⊣ ``		·vtrucia:	<u> </u>	-			Calibration						
-	Torque W			" ├	Drawing Finish	\mathbf{H}		equence						
	Turning S Wave/Tw			-	Folio			Dimensions						
1		ยอน แก้ เป็น	של		FOIIO	1 10	utside	ひいいていいひいろ	*					

DQA:

Date:

Wave/Twist in Tube

Friday, June 21, 2013 4:00:17 PM

Work Order ID: 103367

103367

Parent Item:

D3914-1

D3914-1

Parent Item Name: Rib

Start Date: 6/21/2013

Required Date: 7/19/2013

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev:A new issue DD 10.03.19 verified by:EC

IPP Rev:B

as per dwg revB DD 10.08.18 verified by:EC

IPP Rev:C 11.01.18 chg

qc5 to 6 DD verf:EC

44	e to o BB ven.	.DC											
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.750W.049		Purchased	No			100	f	1,266.072	8	16.84211			
M304TS0		049							**	<i>S</i>	D L	3-09-	24
				Location		Loc (<u>Oty</u>	Loc Code					
				MAT017		41.4652	2084						
					124492	41.4652	2084						
				WA006		1224.607	7382						
					123484	28.9999	9555						
					125124	369.7	7539		_				
					125575	225.853	3527				_		
					M126039		600		2	34.2103			

												DQA:	Da	te:	
NCR:	⁄es	/ No				WORK ORDER NON-C	CO	NFOR	MANCE / UF	PDATE					
_					*	<u> </u>					_(QA Closed:	Da	te:	
Work Orde	er:					DISPOSITION				AGAINST D	ΕP	ARTMENT/	PROCESS		
Part No.						Rework Scrap Use-as-is		Skid-tube Crosstube Small Fab Thermoforming Finishing			Prod. Eng. Coor.				Engineering Quality Other
NCR N	No.					Work Order Update]		Large Fab	Composite]	•	Supplier	_	
Root					Descri	ption of work order update		nitial	A	ction	Т	Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Des	cription	\perp	Date	Verificatio	n	QC Inspector
Doc/Data											T				
Equip/Tooling					1						1				
Operator															
Material					ļ										
Setup															
Other											١				
Process											1				
Supplier]											ļ
Training															
Unapproved															
						F	AUL	T CATE	GORY						
Landi	ng (Gear				General		_						_	
		Bending			. [Bend		Grain			_](Ovalized		L	Pressure/Forced
		Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		_]c	Over/Under	tolerance		Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		_],	Part Incorrect			Weld
		Crushed/	Crimped			Burrs Instructions Incomplete/Unclear				/Unclear	٦	- H			Wrong Stock Pulled

Maintenance

Out of Calibration
Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Part Moved

Positioned Wrong

Power Loss/Surge

Other

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

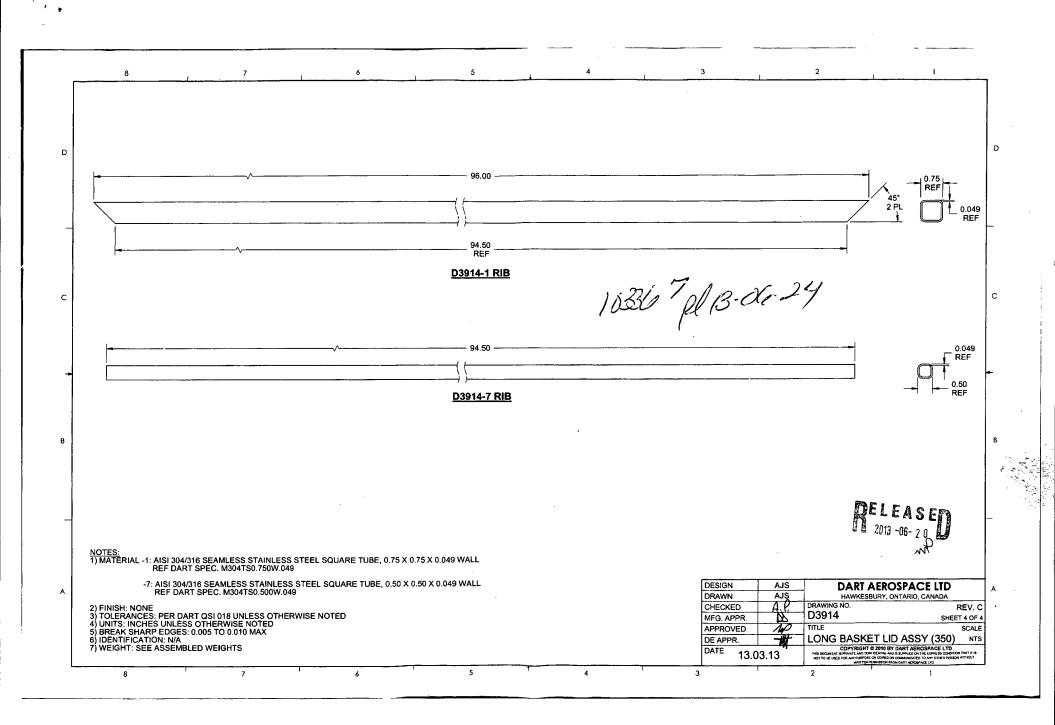
Ripples in Bend

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion



NCR·	Yes	/	No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA:

WCK.	es / 110				WORK ONDER NOW				QA Closed:	Date	• a		
Work Orde	ŗ.				DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part N				····	Rework Scrap	4 1	Skid-tube Machining	Crosstube Small Fab	4	Water Jet d. Eng. Coor.	Engineering Quality		
NCR No.					Use-as-is Work Order Update	Then	moforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other		
Root				Descri	ption of work order update	Initial	Act	tion	Sign &				
Cause	Date	Step	Qty	(or Non-conformance	Chief Eng	Desci	ription	Date	Verification	QC Inspector		
Doc/Data													
Equip/Tooling]										
Operator]	1						1				
Material		1			*			•					
Setup					.								
Other		1				,			<u> </u>	1			
Process													
Supplier						-							
Training													
Unapproved		<u> </u>	<u> </u>										
			•		F	AULT CATE	GORY				···		
Landin	ng Gear				General	,			•	-	¬ ,		
	Bending				Bend	Grain			Ovalized		Pressure/Forced		
	Centre N	ot Conce	ntric to C)/S	BOM/Route	Hardw	are	<u></u>	Over/Under	tolerance	Temperature/Cure		
[Cracks				Broken/Damaged	Inspec	tion Incomplete		Part Incorre	ct	Weld		
[Crushed/	Crimped			Burrs	Instruc	tions Incomplete/I	Unclear	Part Lost/M	issing	Wrong Stock Pulled		
	Cuffs				Contamination	Maint	enance		Part Moved				
	Heat Trea	at			Countersink	Mislab	eled		Positioned V	Vrong	_		
	Inspectio	n Strip in	Tube		Cut Too Short	Misrea	d		Power Loss/	Surge	Other		
	Ripples in	n Bend			Drill Holes	Offset							
·	Torque V	Vaves in I	Extrusion		Drawing	Out of	Calibration						
Ì	Turning S	Sequence	!		Finish	Out of	Sequence						
1	Waye/Tu	-			Teolio	Outsid	e Dimensions						

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G